

PATENT ABSTRACTS OF JAPAN

(11)Publication number : 2000-233625
(43)Date of publication of application : 29.08.2000

(51)Int.Cl.

B60G 21/055
B21D 53/86

(21)Application number : 11-036003

(71)Applicant : NHK SPRING CO LTD

(22)Date of filing : 15.02.1999

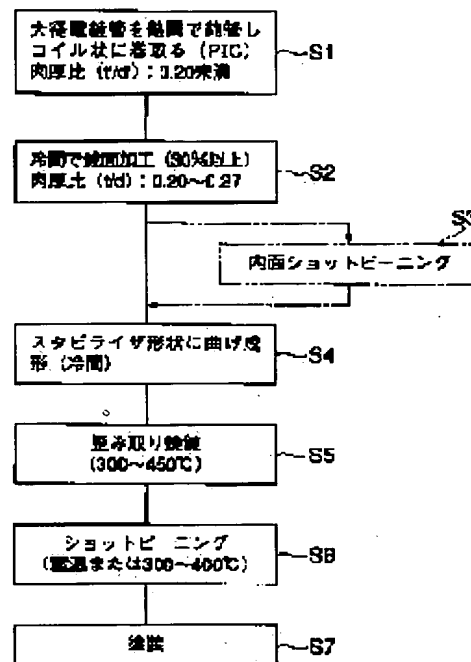
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(54) MANUFACTURE OF HOLLOW STABILIZER

(57)Abstract:

PROBLEM TO BE SOLVED: To satisfy a sufficiently lighter weight and durability by cold drawing a raw tube so as to have a specified area reduction ratio or more to provide a thick pipe material having a thickness ratio within a specified range larger than an electro-resistance-welded steel tube and a specified tensile strength, and cold bending it into a stabilizer shape.

SOLUTION: An electro-resistance-welded steel tube of major diameter is hot contracted to provide a lengthy raw tube (S1). In cold drawing process, the area reduction ratio is increased to 30% or more, and the thickness ratio (t/D) to 0.20-0.27 to provide a thick pipe material having a tensile strength of 800-1000 N/mm² (S2). Inner surface shot peening is performed as occasion demands, and the thick pipe material is cold bent by use of a forming machine and molded into a desired stabilizer shape (S3, S4). It is heated to about 300-450° C by an oven to remove the toxic residual stress (S5). Thereafter, shot peening and rust preventing painting are performed (S6, S7). According to this, a lighter weight and durability can be satisfied.



LEGAL STATUS

[Date of request for examination]

[Date of sending the examiner's decision of rejection]

[Kind of final disposal of application other than the examiner's decision of rejection or application converted registration]

[Date of final disposal for application]

[Patent number]

[Date of registration]

[Number of appeal against examiner's decision of rejection]

[Date of requesting appeal against examiner's decision of rejection]

[Date of extinction of right]